

APPROVED

AMS/LS/STDZ/Rm 362897

**UNITED STATES DEPARTMENT OF AGRICULTURE
AGRICULTURAL MARKETING SERVICE
LIVESTOCK AND SEED DIVISION
USDA SCHEDULE CBR
COOKED BEEF ROASTS, SLICED, FROZEN
MARCH 1997**

SCOPE

This schedule is for use by USDA for the procurement of chunked and formed roast beef, cooked, sliced and frozen. Roast beef slices may be derived from graded or ungraded carcasses.

APPLICABLE DOCUMENTS

The following documents will be incorporated as part of this schedule:

- IMPS General Requirements, Interim, Effective June 1996.
- IMPS For Fresh Beef Products, Series 100, Effective June 1996.
- IMPS Quality Assurance Provisions, with revisions that are Effective June 1996.
- Meat Grading and Certification Branch (MGCB) Instruction Manual, Series 910 and 918.

ORDERING DATA

I. ITEM AND CHECKLIST OF REQUIREMENTS

- A. ITEM: COOKED ROAST BEEF, SLICED - Sliced roast beef shall be derived from chunked and formed, cooked beef roasts, with 10 percent added ingredients. Roasts shall be thinly sliced, round in shape, and shingle layered. Five pounds of shingled slices will be vacuum packaged. Eight packages will be packed into containers to a net weight of 40 pounds. The fat content shall be 5.0 percent fat (plus or minus 2 percent). The product shall be produced in accordance with Food Safety Inspection Service (FSIS) regulations and the following checklist of requirements.

B. CHECKLIST OF REQUIREMENTS

1. MEAT COMPONENTS

- a. Beef must originate from U.S. produced livestock and will be verified in accordance with MGCB Instructions.
- b. The formulation of meat components shall comply with the PRODUCT FORMULA (Section I. B. 3.).
- c. Beef shall be the only meat ingredient and shall include whole muscles and meat binder.

(1) Whole muscles - Shall be as described in **IMPS Item No. 139 - Beef, Special Trim, Boneless**, except for the following additional requirements: The whole muscle component shall be derived from any combination of the following muscle systems from the beef round which are maintained in the fresh-chilled state until processing (refer to the IMPS General Requirements, section I. Meat Handling). Acceptability of the whole muscles for compliance shall be determined by MGCB in accordance with the IMPS Quality Assurance Provisions. Contractors shall declare which of the following muscle systems will be offered prior to examination by MGCB.

- (a) Inside Round, Cap Off - The inside round shall consist of the semimembranosus, adductor muscles and may include the pectineus and sartorius. The gracilis muscle shall be removed.
- (b) Outside Round (flat) - The outside round shall consist of the biceps femoris muscle (which includes the biceps femoris ischiatic head).
- (c) Eye of Round - The eye shall consist of the semitendinosus muscle.
- (d) Peeled Knuckles - Only the rectus femoris and vastus lateralis muscles shall be included. The rectus femoris shall be butterflied to expose and remove the connective tissue within. The vastus medialis and vastus intermedius shall be excluded from the whole muscle portion of the formula.

(e) Trimming - Whole muscles shall be trimmed in accordance with **IMPS Series 100**, section **D. FAT LIMITATIONS**, peeled/denuded, and surface membrane removed, option no. 6 and **II. MATERIAL REQUIREMENTS**. Apply defect 138 within Defect Classification Table 100 H of the IMPS QAPs accordingly:

138 Less than 90 percent of lean exposed or remaining fat exceeds 1/8 inch (3 mm) depth at any point (score no more than once per sample unit).

(2) Binder - The contractor shall assure that the binder material is derived from beef that complies with IMPS Item No. 138 - Beef Trimmings. The beef shall be finely ground or emulsified.

2. NON-MEAT COMPONENTS - The non-meat ingredients and their amounts shall be in accordance with the product formula and shall be listed in the ingredient statement.

3. PRODUCT FORMULA (RAW)

| Component | Percent |
|--|---------|
| Meat | |
| Whole muscles, fresh-chilled (minimum) . . | 77.28 |
| Ground Beef Binder (maximum) | 13.63 |
| Non-Meat | |
| Water | 6.54 |
| Sodium Phosphate(s) | 0.45 |
| Salt | 1.10 |
| Flavorings * | 1.00 |
| Total | 100.00 |

* Flavorings shall include beef extract, rosemary extract, garlic powder, and onion powder (no individual ingredient shall exceed 40 percent of total flavoring component).

4. PROCESSING

- a. The whole muscle component shall be ground through a plate having holes no smaller than 1.25 inches (31 mm).
- b. The meat used as binder material shall be finely ground ($\frac{1}{8}$ grind or less) or emulsified.
- c. All components shall be blended and may be allowed to “rest” to enhance binding.
- d. Blended components shall be stuffed into casings and heat processed (cooked) to reach an internal temperature of not less than 165°F.
- e. Slicing - The encased product (logs) shall be reduced in temperature and thinly sliced (not shaved). The logs may be sliced in their entirety. Cooked end pieces left over after slicing may be incorporated into subsequent lots provided: (1) it is processed with the binder materials; and (2) meet FSIS regulations. Slices shall be:
 - (1) no greater than $\frac{1}{8}$ (3 mm) inch thick,
 - (2) shingle layered,
 - (3) full intact slices (approximately round shaped)
 - (4) no more than 5.5 inches in the longest dimension.

5. PACKAGING AND PACKING

Product shall be packaged and packed in accordance with the IMPS General Requirements and the following additional requirements:

- a. **Packaging** - Five (5) pounds of shingled slices shall be placed within each package. Packages shall contain no more than 2 layers of shingled slices. Product shall be vacuum packaged without the use of metal or plastic clips.
- b. **Packing** - Eight individual packages shall be packed into shipping containers to a net weight of 40 pounds (18.1 kg). Only one style and size of container shall be used in any one delivery unit.
- c. **Closure** - When the strapping method is used for final closure of slotted containers that have not been assembled using a tuck lock method, the initial closure will be secured in accordance with the gluing method.
- d. **Marking of Shipping Containers** - Markings shall be as illustrated in Exhibit A (attached). Lot and box numbers shall be sequential, beginning with the number 1.
 - (1) All Nutrition Labeling will be in accordance with FSIS regulations, 9 CFR Parts 317 and 320. Nutrition Labeling is required on shipping containers as indicated in the exhibit.
 - (2) Product produced in State-inspected plants operating under Section 301 of the Federal Meat Inspection Act, must comply with State regulations and be equal to USDA, FSIS, applicable regulations.
- e. **Palletized Unit Loads** - Required. Contractors are encouraged to arrange for pallet exchange with consignees, USDA is in no way responsible for such an arrangement.

6. METAL DETECTION

- a. Testing shall be conducted: (1) during the stuffing process using an in-line divert metal detection system; and/or (2) after fabrication of finished product, before or after packaging.
- b. The equipment used shall be capable of detecting the presence of 3.0 mm, 440 stainless steel test standard.

7. STATE OF REFRIGERATION

The finished product shall be frozen, FREEZING OPTION 1. (Refer to IMPS General Requirements, Meat Handling).

8. FAT LIMITATIONS



The finished product shall be 5.0 percent fat (plus or minus 2 percent). Declared fat content shall be reflected in the Nutrition Facts Panel appearing on the container in accordance with FSIS nutritional labeling regulations (percent fat = (Total fat ÷ Serving Size) x 100)).

II. QUALITY ASSURANCE

- A. Contractor s Responsibility - The contractor shall have a documented quality control program demonstrating conformance to the CHECKLIST OF REQUIREMENTS. Documentation (records) shall be made available to the MGCB agent for review. All written procedures and associated records shall be maintained and readily available for review by AMS agents. Records may be maintained on hard copy or electronic media. However, records maintained on electronic media shall be made available in hard copy immediately upon request by AMS. The contractor s quality control program shall include:**
- 1. documentation (records) that provide objective evidence that product offered for final certification complies with the CHECKLIST OF REQUIREMENTS within the ORDERING DATA section of this schedule.**
 - 2. documented plans for corrective action when deficiencies are found.**
- B. Certification of the Whole Muscle Component - The whole muscle component shall be certified by MGCB for conformance with section I.B.1.c.(1).**
- C. Verification of Quality Control Program - At the time of initial production, AMS auditors shall review the contractor s quality control program for adequacy and follow the initial production through placement of finished product into the freezer. Deficiencies shall be corrected at that time. After initial production, AMS agents will randomly monitor operations and evaluate the quality records.**
- D. Final Certification - At the time of shipping the AMS agent will:**
- 1. Conduct an examination for temperature (IMPS, QAPs)**
 - 2. Conduct an external Condition of Container exam. This exam is limited to defects which may have occurred during handling and storage (e.g., crushed, torn, dirty, stained, etc.). All defective containers must be replaced or corrected, as applicable.**
 - 3. Supervise the loading and sealing of each truck.**
- E. Acceptances and Certification - The AMS agent will certify acceptable product and set forth on the original certificate the following:**
- 1. Contract number.**
 - 2. Notice-to-Deliver number.**
 - 3. Name of product.**
 - 4. Production lot number(s) and the date each lot was produced.**
 - 5. Count of shipping containers and total projected net weight in each production lot. The delivery unit shall be 40,000 pounds (18,144 kg) net weight.**
 - 6. Identity of car or truck (car numbers and letters, seals, truck license, etc.) as applicable.**
 - 7. Product conforms with (Schedule CBR).**
 - 8. Count and projected net weight verified.**

EXHIBIT A

SHIPPING CONTAINER MARKINGS: SHIPPING CONTAINERS SHALL BE MARKED SUBSTANTIALLY AS SHOWN BELOW. BAR CODES MAY BE ADDED AS LONG AS THEY DO NOT INTERFERE WITH REQUIRED MARKINGS. NO OTHER MARKINGS WILL BE ALLOWED. MARKINGS SHALL BE BLACK, FLAT, WATERFAST, AND NONSMEARING. THE USDA SYMBOL SHALL BE AT LEAST THREE AND ONE-HALF (3 1/2) INCHES (8.9 CM) HIGH. ALL OTHER PRINTING OR STENCILING SHALL BE OF A SIZE TO STAND OUT PROMINENTLY AND COMPLY WITH THE USDA-FSIS REGULATIONS. THE WORDS "COOKED ROAST BEEF, SLICED" SHALL STAND OUT MORE PROMINENTLY THAN THE OTHER LETTERING.

| | | |
|---|---|--|
| | COOKED ROAST BEEF, SLICED - FROZEN | |
| COOKED ROAST BEEF, SLICED - FROZEN DONATED BY THE U.S. DEPARTMENT OF AGRICULTURE FOR FOOD HELP PROGRAMS NOT TO BE SOLD OR EXCHANGED | <p>The frozen cooked roast beef slices are fully cooked, thinly sliced, shingle layered, and placed into 5 pound (2.27 kg.) packages. Each shipping container contains eight (8) packages. Each 5 pound package will provide approximately 76-1.05 ounce servings, each of which contributes 1.0 ounce of equivalent meat towards Child Nutrition Meal Pattern Requirements.</p> <div style="border: 1px solid black; padding: 5px; margin: 10px 0;"> <p style="text-align: center;">*</p> </div> <div style="border: 1px solid black; padding: 10px; margin: 10px 0;"> <p style="text-align: center;">Nutrition Facts</p> <p>Nutrition Facts must comply with USDA-FSIS regulation 9 CFR 317 and 320.</p> <p>For State inspected plants, nutrition labels must be in accordance with State regulations that are equal to 9 CFR Parts 317 and 320.</p> </div> <div style="text-align: center; margin: 10px 0;">  </div> <p style="text-align: center;">PERISHABLE FROZEN - STORE AT 0°F (-17.8°C) OR BELOW</p> <p>Remove packages from shipping container. Keeping in original wrappings, place in single layer in shallow pans, and thaw in refrigerator allowing approximately 1 to 2 days. Remove slices from packages and place into preheated oven of 325°F and heat approximately 20 minutes per pound to an internal temperature of at least 140°F. Seasonings, gravy, or sauce may be applied to the surface of the slices prior to heating. Meat may be heated without first thawing, but increase heating time by approximately 1 1/2 times.</p> <p>The product may also be served cold. Refrigerate leftovers and serve within 24 hours. Do not refreeze.</p> | COOKED ROAST BEEF, SLICED - FROZEN DONATED BY THE U.S. DEPARTMENT OF AGRICULTURE FOR FOOD HELP PROGRAMS NOT TO BE SOLD OR EXCHANGED Ingredients: |
| | <p>COOKED ROAST BEEF, SLICED - A603 (Chunked and Formed) 10 percent added ingredients Schedule CBR CONTRACT NO. _____</p> <p style="text-align: center;">KEEP FROZEN</p> | <p>DATE PACKED</p> <p>_____ LOT _____ BOX _____</p> <p>NET WT. ____ LBS.</p> <div style="text-align: right;">  </div> |

NOTES: DATE PACKED SHALL BE THE MONTH, DAY, AND YEAR OF PACKING.
 SERIAL CONTRACT NUMBER WILL BE FURNISHED BY USDA.
 LOT NO. AND BOX NO. MAY BE PLACED ON THE SAME LINE OR AS SHOWN ABOVE.

PER 9 CFR 317.4 & 317.5, PRIOR APPROVED LABELS NEED NOT BE RESUBMITTED, EXCEPT FOR CHANGES TO THE "NUTRITION FACTS" SERVING SIZE. CONTRACTORS THAT DO NOT HAVE APPROVED LABELS ON FILE MUST SUBMIT LABELS IN SKETCH FORM ONLY TO USDA, FSIS, FOOD LABELING DIVISION (FLD) OR STATE AGENCY AS APPROPRIATE.

* FOR STATE INSPECTED PLANTS, (1) REPLACE FEDERAL INSPECTION EMBLEM WITH STATE INSPECTED EMBLEM, ON PRIMARY PANEL, AND (2) PLACE THE FOLLOWING ON THE TOP PANEL ABOVE THE USDA SHIELD: "INSPECTED BY THE STATE OF (STATE'S NAME) AND MAY NOT CROSS STATE LINES."